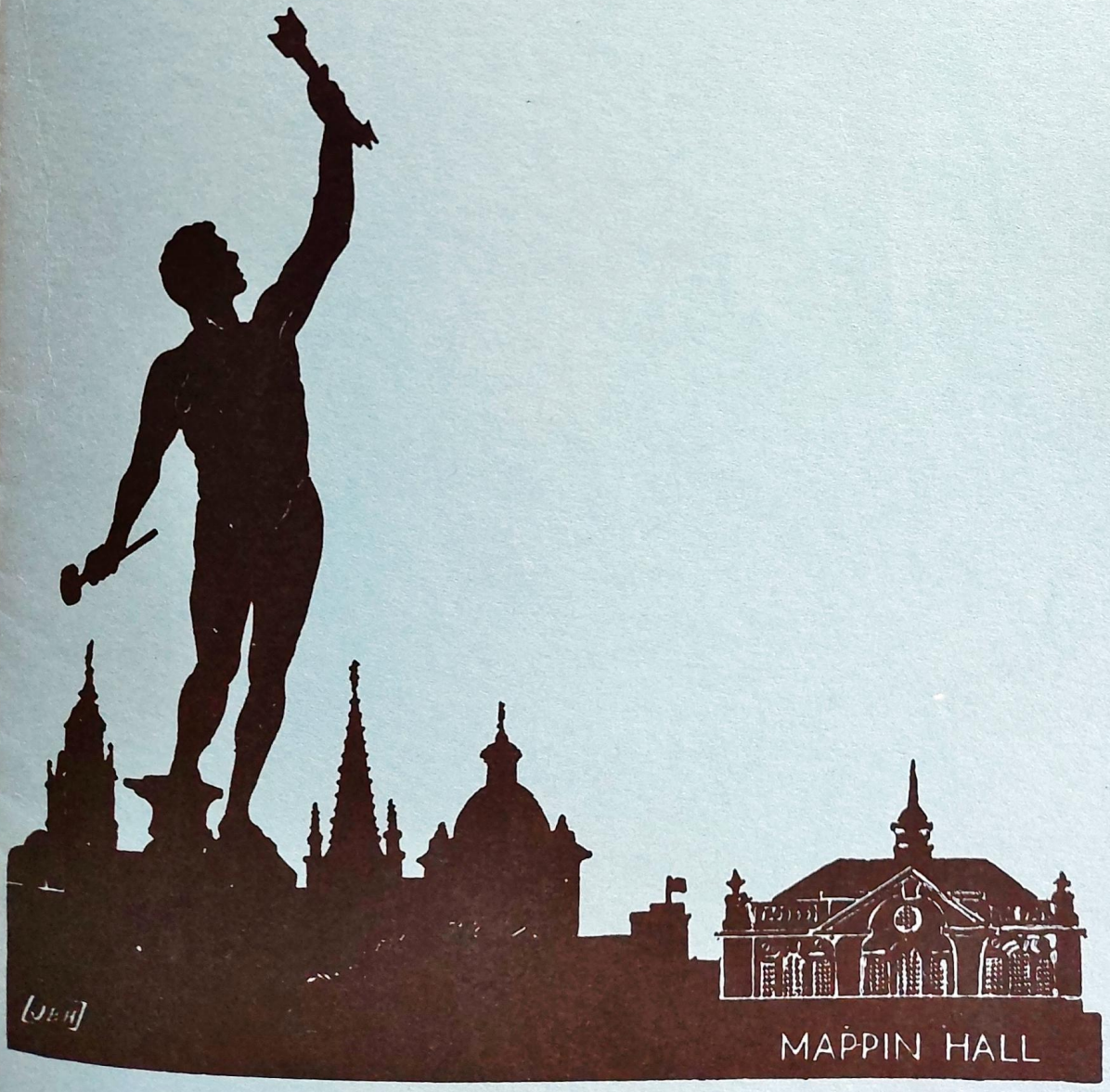
A GLOSSARY OF
OLD SHEFFIELD
TRADE WORDS AND
DIALECT



Sheffield Trades Historical Society
(formerly Society for Preservation of Old Sheffield Tools)

A GLOSSARY
OF
WORDS AND DIALECT

Formerly used in
THE SHEFFIELD TRADES.

PART I.

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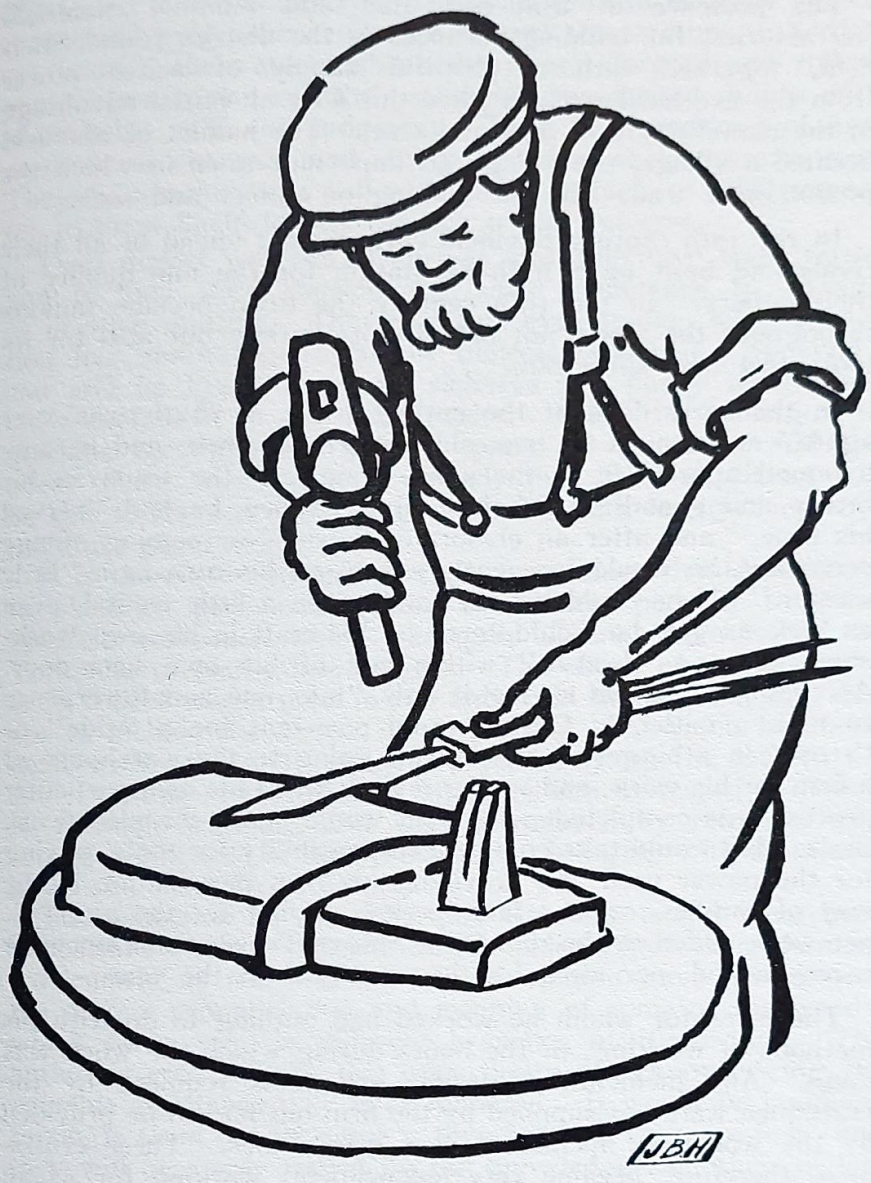

A Hand Forger.

INTRODUCTION.

Sheffield has been famous for many centuries for its high grade cutlery and its steel. As early as the 14th century, Chaucer described the Miller in his Reeve's tale as having a Sheffield "thwitel." In more recent times John Ruskin has complimented the Sheffield craftsmen upon their artistic work.

The presence of iron ore, fuel and suitable materials (refractories) for building furnaces in the district round Sheffield, together with a plentiful supply of water power from the five local streams gave this City an initial advantage in the manufacture of iron and steel. The hamlet of Sheffield became a village, the village an important town in which the predominant trade was the making of cutlery and tools.

In the 18th century Sheffield cutlers went ahead of all their rivals and built up a high reputation for the fine quality of their cutlery. In the 19th century the town became famous throughout the world not only for its cutlery but also for its tool steel and silverware.

In the early days of the cutlery trade, a youth was "set agate" as soon as he was old enough to work, and became a bound apprentice at the same branch of the trade as his father and grandfather before him. When he had "served his time," and after an elaborate "loisin," or coming of age ceremony, he would frequently set up on his own as a "little mester." If he could lay his hands upon a little capital, even as little as £5, he would carry on his craft in his own workshop, often a "lean-to" within call of his own back-door. According to an old saying it only "taks one and fowerpence to mak a cutler." Or he would pay rent for a "side" or "trow" in a bigger establishment, going to the warehouse of a firm for his work, and taking it back when his own particular process was completed. Payment would be on the piece-work basis. He would take complete responsibility for tools, paying for the power used and providing his own illumination in the way of candles, or at a later period, paying for the gas—3d. per week added to the rent from Shrove Tuesday to Doncaster races and 6d. per week for the remainder of the year.

The firms for whom he worked had nothing to do with his methods of working, or the hours during which the work was done. Any incidental materials and tools required by the craftsmen were not supplied by the firm but had to be provided by the workmen, including even grindstones. These craftsmen, therefore, became very independent, working for whom they pleased, and taking time off when they wanted. Work was rarely started in the week before Tuesday, for there were many out-door attractions on "Saint-Monday."

Before the days of steam power and the large factories, the work in Sheffield was done in small works or "wheels" built on one of the five streams: the Don, Sheaf, Rivelin, Loxley or Porter, and each was equipped with one or more water wheels to drive the tiny factory. Some of these "Wheels" are

illustrated in the Glossary. The practised eye of these skilled men could judge accurately the correct temperature to harden or "work" their steel, whilst the tilters, forgers and rollers could hammer and roll their steel into the desired shapes with remarkable skill and judgment. They were cautious of new methods or changes, and almost proud of their conservatism. They did not mix very well with the inhabitants of other towns, for to them Sheffield was the hub of the universe.

Their dialect was full of curious and individual trade terms and in this they showed the same reluctance to change as in other matters. Thus it is that even to-day, when education has almost destroyed the dialects, the true "Shevvild" can still be heard in all its richness and purity among the older craftsmen in the local trades. With the transition to machine methods, the further spread of education and the effect of the wireless, it is unlikely that Sheffield dialect will be able to last out much longer. It will be a foreign language to future generations.

It is therefore appropriate that some effort should be made to place on permanent record the dialect peculiar to these Sheffield craftsmen which was quite distinct from either the Yorkshire or Derbyshire dialects. The object of this Glossary is to collect words used in the industrial life of the City, and not to include the dialect of the normal life, which has been dealt with adequately already, particularly by the late S. O. Addy. Some of these industrial terms can be traced to Dutch or Flemish originals, and were introduced by refugees who settled in Sheffield in the Middle Ages, bringing with them new ideas and methods of manufacture.

The collection of words in this Glossary would have been impossible without the aid of the older Sheffield craftsmen, particularly as many differences of opinion have arisen over the correct pronunciation and meaning of some of the words, which often vary in different branches of the trades. The author is glad to take this opportunity of acknowledging the valuable assistance they have rendered. It would be invidious to single them out by name ; they were all eager to help, and they will be amply repaid by the knowledge that their dialect will be given a permanent record.

In his personal contact with these craftsmen the author has been much impressed by their profound knowledge, not only of the details of their work but also of its historical, literary and artistic aspects. Some of them as in the case of the late T. R. Ellin, J.P., a former Master Cutler, have made a practice of keeping written records of the dialect, trade terms and incidents which have taken place within their experience.

B. RONALD DYSON.

Sept., 1936.

PREFACE.

[By The Rt. Hon. Lord Riverdale of Sheffield, K.B.E., LL.D., J.P.]

When we remember that the great reputation of Sheffield all over the world for Steel and Cutlery really started from the invention of Benjamin Huntsman, it is more than worth while to create a museum of the old Sheffield craftsmen's work so that future generations with scientific and industrial advantages, about which our forefathers knew nothing, may be impressed by the greatness of these old Sheffielders who produced Steel, Cutlery, and Tools of a quality which called forth the admiration of the whole world.

The happy suggestion to house these old Sheffield records in the ancient Abbeydale Works, and to re-equip the old seven-hole melting furnace there and keep it as a memorial of tens of thousands of tons of Crucible Steel which were shipped to every part of the world and brought not only a good name to Sheffield but also great prosperity, surely should be accomplished without any great difficulty.

Looking back to-day and considering the methods of transport and communication of those old times, it was a marvellous thing that Sheffield was able to extend its trade to the farthermost corners of the world; but Sheffield men of those days went out and took the risks of travelling abroad which then existed.

Coming to later years when America, France, Germany, Italy and other countries have equipped themselves to supply Steel, Cutlery, Files and Tools for which Sheffield was famous, the fact that the old Town has, by means of scientific and industrial research and courageous application to the difficulties which confronted it, been able to re-establish itself as the world's greatest centre for Alloy Steels and high-class production, is surely something which is well worth recording and it behoves us all to do everything we possibly can to maintain and widen the great reputation of Sheffield.

This museum and this strange dialect of the past should be incentives to us to be as proud of our Town and as active in its support as were our forefathers.

To Mr. David Flather and his colleagues who are responsible for the suggestion of the museum we should all be very much indebted as without their thoughtfulness so much of Sheffield's Industrial History might easily have been lost.

RIVERDALE.

Glossary of Words Used in Sheffield Trades.

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The pronunciation of each word is given in brackets, in International Phonetics.

KEY.

	Standard Speech.	Phonetic Transcription.
a heard in	how.	h*a*u.
a: ,, ,,	father.	fa:ðə.
a ,, ,,	fly.	flai.
æ ,, ,,	cab.	kæb.
æ: ,, ,,	(Sheffield) pain.	pæ:n.
ʌ ,, ,,	much.	mʌtʃ
e ,, ,,	red.	red.
ei ,, ,,	play.	plei.
ə ,, ,,	above, china.	ə·bʌv, tʃainə.
ə: ,, ,,	bird.	bə:d.
ɛ: ,, ,,	there.	ðɛ:ə.
i ,, ,,	lip.	lip.
i: ,, ,,	feel.	fi:l.
o ,, ,,	low, road.	lou, roud.
ɔ ,, ,,	long.	lɔŋ.
ɔ: ,, ,,	law.	lɔ:.
u ,, ,,	good.	gud.
u: ,, ,,	food, boot.	fu:d, bu:t.

: after a vowel means it is pronounced long, *a:*.

· before a syllable means that that syllable carries the accent . above, ə·bʌv.

Consonants.

ð heard in	that, then.	ðæt, ðen.
θ ,, ,,	thin, thick.	θin, θik.
ʃ ,, ,,	shell.	ʃel.
ŋ ,, ,,	thing.	θiŋ.
ʒ ,, ,,	measure.	·meʒə.

h in the purest dialect is almost non-existent.

A.

Agon (·agən, ·agaiən) or hagon. An inverted chisel fitted cutting edge uppermost in a socket on the forger's anvil, to cut off the mood.

Albert (·albət). A palette neck carving knife.

Arseboard or horseboard (·a:sbu:əd). A board slung from behind the grinder to serve as a seat. It extends forwards between his legs to the wheel. His weight when sitting on it converts it into a powerful lever for pressing objects to be ground on to the stone.

Arston (·a:stən). Hearthstone.

Ass hoil, ass nook (·asɔil, ·asniu:k). The place under the grate where the ashes drop. From Old Norse aska, Danish aske.

Assidue, assigue (·asigiu:). Thin Dutch metal or gold foil used to adorn the handles of cheap pocket knives. Used to denote anything very thin: "Thin as assidue. . . "

B.

Backsaddle (·baksadl). The back pair of hooks carrying the chains which hold down the horsin. See also "Front saddle."

Back spittle. A wooden shovel.

Balanced handle (-·andl). The handle of a knife so balanced, either by good making or subsequent weighting, as to keep the blade off the table cloth when laid down.

Band (band). String; also, a power belt, a flat strap passing over two wheels. c.f. Dutch, band, meaning string, and German Band, tape.

Barkle up (ba:kl up). A verb, to clog up a glazer.

Barmskin (·ba:mskin). A leather apron used by cutlers. Old English barm, bosom.

Batts (bats). Ashes left on the bolster of a knife from the prints. The grinders call these fashes.

Bat. A hard piece of coal or shale.

Beard (bi:əd). A very short bolster, a sort of rounded half-bolster; the tip of a knife haft.

Bearded. Of a penknife, having a very short bolster.

Bearstake (·bɛ:əsteik). Several bands run from the grinder's main drum. To prevent these from creeping up on to the list when in motion, a grindle cowk stands between each pair, with a stick, or bearstake (bearing stake) standing upright in its central hole.

Beckhorn or beckiron (·bekaiən). A beak shaped tool, part of the anvil, over which forgings are bent. A smaller version of the main horn of the anvil. The word is a corruption of the French Bigorne, an anvil with two pointed extremities.

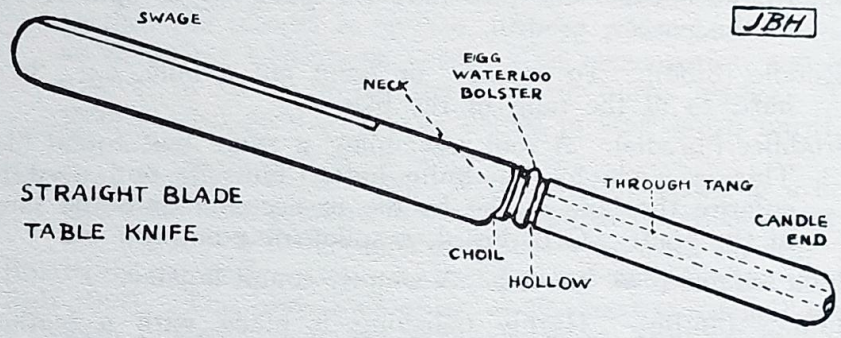
Bellus, or belluses (·beləsəz). A forger's bellows. Generally used in the double plural form.

Benk (beŋk). A bench.

Bitin' on, or bite on (·baitin·ɔn). A snack eaten about eleven in the morning during a short interval from work. Generally used to be bread and cheese and beer.

Blank (blaŋk). The rough unworked stamping in metal of any article.

Bolsters, or bowsters (·boustəz). The projecting shoulder of metal on a table knife blade where it is inserted into the handle ; lying between the blade and the tang, like a tiny sword guard. Also, the metal end of the scale of a pocket knife, carrying the pin on which the blades turn ; this is often left bare, and highly polished.



Bolster stone (·boustə·stu:ən). A narrow grindstone of very hard grit for grinding the bolsters of table knives, etc., and especially for removing fashes. This stone came mostly from about the Rivelin district,, and is cut into wheels of 1¼ to 1½ inches broad by 22 inches diameter.

Boring stick (·bɔ:rinstik). A twisted strip of leather thong fastened to both ends of a stout stick, like a bow with no tension in the cord. This strap passes round the bobbin of the parser, and a sawing motion of the stick rotates this bobbin, and the drill it carries.

Bosh (bɔʃ). A vessel containing water for quenching heated blades. Generally, a circular tub.

Boss and punch (bɔs ən punʃ). Used by the hafter when making his own caps (to fit on knife hafts) from various metals.

Boulder, bowder (ˈboudə). A glazing wheel newly dressed with emery is rough. Bowder is the hard stone used, with a little grease, to smooth it down, so that it will put colour in the polish, i.e., give the metal a smooth black surface of very high polish.

Bowder. To straighten up the bolster stone mentioned above.

Brat (brat). An apron (pronounced apperon, or appron) worn by cutlers. Obsolete amongst cutlers, but still used in Bradford for an overall, and also among Sheffield buffer girls.

Breaking down (ˈbræ:kin ˈda:n). The first rough grindings of a blade to remove surplus material and scale, and bottom any cracks. This process requires tremendous pressure, so with the harder steels it is done before tempering, i.e., in the soft. Same as o'erholding.

Breast, or breast plate (ˈbrest plæ:t). A metal plate strapped to the cutler's chest to take the gudgeon or spindle end of the parser, or drill.

Broddle (brɔdl). To enlarge, or ream out a hole, e.g., in a haft, to fit the tang of the blade.

Broddler (ˈbrɔdlə). A tool resembling a small half round file. This is made by the knife hafter himself, and used to enlarge the hole in the handle to accommodate the tang of the blade. O.E. brord, a spike, or point.

Buck bolster (buk boustə). A simple, round bolster.

Buffing (ˈbufin). Highly polishing a blade with a leather covered wheel, or buff. The wheel is of wood, usually covered with "sea horse" or bull neck leather, dressed with emery. The handles of knives are buffed on the "dolly," a wheel of many discs of cloth clamped together, The name is due to the original covering of the wheel, buffalo leather.

Buffalo, or buffler (buflə). Ox, or buffalo horn used for the handles of knives, mostly pocket knives. Grey buffler came from cow horns, black buffler from buffaloes.

Buff stick (ˈbuf stik). A flat piece of wood like a leather stick, faced with rhino leather, $\frac{3}{4}$ inch by $1\frac{1}{2}$ inch. The article to be polished is rubbed with this, dressed with whitening to remove the buffing grease, then wiped with chamois (shammy) leather.

Bug blinding (ˈbug blɑːindin). Limewashing the workshop, and generally cleaning up.

Bull Week (bʌl wiːək). The week before Xmas, when cutlers "bulled at wark," or made an extra effort. Overtime was worked, to addle a bit extra to make up for the holiday, and provide for the festivities. No wages were paid on the Saturday before Xmas Day ; the earnings from the previous Saturday right up to Xmas Eve were handed over on the Eve, the period between these two days being the Bull Week.

Bullet bolster (ˈbulit ˈboustə). A rounded bolster, frequently fitted to a candle end knife.

Burnish (ˈbəːniʃ). A burnisher, or burnishing steel. A smooth steel, similar to those used for whetting carving knives used with considerable hand pressure to brighten the backs, bolsters, choils and insides of springs of pocket knives. The high polish thus obtained resists rusting. Often the burnish is made of an old file, smoothed in one place for the polishing surface, turned over at the tang into a simple hook and ring socket, and fitted on to a wooden base like a sway knife, for ease of handling.

Burnt blades (bəːnt blæːdz). Blades overheated on the wheel, so that the temper is spoiled. A dry wheel blues blades, so that they twitter, or twist. Too clean water, too low a level of swarf in the trough, also burns blades. The term is also used of knives hafted in stag horn, burnt at the bolster ends to give colour.

Burritted heads (ˈbəritəd ˈedz). Rivet heads protruding a little from the handle of the knife, and finished and polished in the form of a little round cap, like a Spanish biretta.

Burritting parser (-ˈpɑːse). A special parser used for the above.

Butt (but). The iron head of an anvil, steel faced and fitted with different slots for agons, choilers, etc.

Buttoning time (ˈbutnin ˈtɑːim). The same as biting on.

Buttyman (ˈbutimən). A sub contractor, similar to little mester.

By race (ˈbɑːi ræːs). The overflow, or bypass of a water wheel dam.

C.

Candle box (kandl bɔks). A triangular box of wood to shield a candle from the draught in the grinding hull. It was fitted with a row of holes down the back to hang on an old file tang stuck in the squat board, so that the box could be adjusted to the height of the work as the wheel wore down. The candle was stuck in by the simple medium of a lump of swarf.

Candle end. A plain round handle named from its similarity to a candle. A knife with this kind of handle.

Cannel (kanl). A minute swage on the edge of a knife blade which has been ground too thin to use.

Cannel. To bevel, or chamfer. When whittening (q.v.) the process of removing the fash, or fetheredge on a blade ground too thin.

Cannelled edge (kanld edʒ). The chamfered edge of a tool, knife or razor when the fetheredge has been removed.

Cap glazer (ˈkap glæːzə). A small hollow in the glazer to take and polish the ends or caps of knife handles.

Capping (ˈkapin). Pinning metal caps on the ends of handles.

Carrot glazer (ˈkarət ˈglæːzə). A glazer tapered according to the radius of curve of the article to be polished. Similar in shape and size to a carrot.

Catch plate (ˈkatʃ plæːt). A large iron plate fitted to the right of the anvil on the stock, to hold tools, blades, etc.

Cat leg (ˈkat leg). A fork with straight prongs, as used by pork butchers.

Chavel (ˈtʃavil). To "chew" or fray a rope or band.

Chine (tʃaːin). To cut through anything.

Choil (tʃɔil). The indentation at the end of a blade where the cutting edge adjoins the tang. A nick, or angling off of the blade to facilitate grinding of the blade right to its handle end without the bolster getting in the way. This choil is made by a special agon fitted on the left ear of the anvil, and called a choiler.

Choil it. To depart in a great hurry.

Clams (klamz). Wooden jaws fitted to the steel jaws of a vice to hold knife handles firmly without marking them. c.f. German Klamm, a cramp.

Clanging steels (ˈklaŋgin ˈstiːlz). Ingots, knife blades, or any other pieces of metal which will make a noise when struck, hung up to make a crude peal of bells at the old fashioned loisin, or coming of age ceremony of an apprentice.

Clasp knife (klasp naːif). A knife with a locking device for the blades when open. Called either a Chinese or a French lock.

Click howd (ˈklik oud). To catch hold of anything.

W. Hayward Young.
1893

Second Endcliffe
Grinding Wheel in 1883

Clinks (klinks). Small surface cracks on a waster or throwout blade. These are the start of a fracture unless bottomed by the grinder, i.e., ground right out. They are found around the junction of steel and iron where the tang is welded on to the blade, due to the different coefficients of contraction of the two metals. Also caused by hammering metal when too cold.

Clip point (klip ·point). A blade like that of a putty knife, with the point trimmed off at an abrupt angle.

Cloudy (kla:di). A white cloudy patch on the surface of a blade shows a soft part, through a fault either in the steel or the making up.

Clout (klaut or kla:t). A cloth used for wiping knives dry and clean.

Clout nail (·klaut næ:l). A nail with a large flat head, used for nailing leather on the drum. Connected with French clou, a nail, possibly ; alternatively, a nail suitable for tacking clouts, or cloth.

Coddy, or caddy (·kade). A type of common, cheap knife. A scale tang.

Coddy bolsters. Bolsters pinned on to a flat blade.

Co' rake (·kou ræ:k). Coal rake, a long iron handled hoe for raking up cokes in the furnace.

Cog (kɔg). To hammer iron with a power hammer.

Coil hoil (·kɔil ɔil). Coal cellar.

Collar (·kɔlə). An entanglement of the band, or driving belt, about the drum and shafting.

Common joint (·kɔmən ·dʒɔint). A pocket knife, with the backs of the blades at the joint sticking up above the level of the scales.

Concealed pin. Table knives pinned on to the haft from the choil edge (i.e., the cutting edge) without carrying the pins right through to the back edge, or "mock pinned."

Cop out (·kɔp ·a:t). To suffer, or be punished for something ill done.

Corbo (·kɔ:bou). A common curved knife of poor finish ; a Wharncliffe knife.

Cott (kɔt). A hottle, or finger stall.

Cotter (·kɔtə). To strike heavily. "I'll gie thee a good cotter if tha dusn't choil it!"

Cotter. A pin through the shank of a bolt to secure it.

Country (ˈkuntre). Cutlery bearing the mark of the customer, not that of the maker. The forgers were paid sixpence a diwerk (day work) for this work, though it was of the same quality as for foreign blades, i.e., bearing the makers' mark.

Crapply (ˈkraple). Brittle steel, short and crumbly in texture, through bad heat treatment.

Crates (kræ:ts). Wooden supports for the front of the horsin. Fitted to the top of the trow, to adjust the level of the horsin and the robin to the height of the work as the stone wears away.

Crocus (ˈkro:kəs). Red iron ore ground up for use as a polish.

Crooked tongs (ˈkriukd toŋz). Tongs with shaped bits (the gripping ends). They are designed to hold a flat blade without slipping, a flange on one arm preventing the blade from flying out of the tongs when hammered.

Cuckoos (ˈkuku:z). Faulty work sent back to be put right. When a man has work returned he is greeted with cries of "Cuckoo" from his mates; i.e., he's getten t'cuckoo.

Cuteau. A large clasp knife. Possible connection with the French couteau, knife.

Cutler (ˈkutlə). Strictly this term only applies to the man who assembles, or sets-in, knives, but it is now extended to workmen in all branches of the trade.

Cutlers' board (— bu:əd). A sloping wooden tray open at the raised side, invariably used for carrying table knives from shop to warehouse.

Cutlers' peas (— peiz). When peas were sold as cheap as 4d. a peck the poor cutler could afford them, not before. At this price they were known as cutlers' peis.

Cut swage (kut swæ:dʒ) or nicked-in- swage. A swage along the back of a blade, having one end cut square. A "bevel" swage, on the other hand, tapers away to nothing at either end. (See Swage.)

Cuttle (ˈkutl). To make knives, or set them in.

Cuttling (ˈkutlin). The art of the cutler.

D.

Dadly (ˈdadle). Dadly blades are blades made thick in the neck, and choiled about 1½ inches away from the bolster, e.g., a butcher's knife.

Dadly. The shoulder or bolster on the above type of blade.

Da'work, or di'work (di·wə:k). A fixed allotment of work (and pay) varying according to the size and quality of the blade, etc. The pay for a diwork was constant, but the amount of work was more or less according to difficulty. Note, that this term does not mean a DAY'S work, as often three or four daworks may be done in a day. The term is used in forging and blade making.

Datalman (·deitlmən) or day-tale man. A journeyman, any man paid by the day, and not by piecework rates.

Dead fingers (di:əd —). Hands numbed when working in cold weather.

Deer stalker. A very high-class bowie knife, or hunting knife. An 8-inch spear point blade, with a dadly, or shoulder about 1½ inches from the bolster.

Dead horse (di:əd ɔ:s). Workin on't deead 'orse means working off "sours," i.e., doing work for which the cutler has already subbed, or drawn his money in advance.

Dessert knives (dizə:t na:ivs or ·dizets). Old term for the smaller size of table knife, now often used instead of the larger and more correct dinner knives.

Devil (-devil). A tool with a straight slit in a metal face, for straightening up twisted blades. It was fitted into a slot in the stiddy. Any tool which produces remarkable results is a devil, e.g., a cutler's marking devil, which marks blades quicker than the old marking plate and parser.

Devil. A tool similar to the above, fitted into a slot on the left side of the forger's anvil, for shaping the bolster when tanging the blade.

Diamond cut (·da:iəmənd ·kut). The diamond shaped scorings on the wooden handle of a common butchers' knife.

Diamond handle (— andl). A square handle fixed so that the straight edge comes in the middle of each side of the blade, i.e., is twisted a quarter turn from the usual position.

Diamond head (— i:əd). A handle with its head in the shape of an octagonal spire, from which it is also called an octagon spire head.

Dish (diʃ). A concavity, or dish shaped hollow in the scales of a knife to make the horn, wood, or pearl coverings pan to, i.e., lie flat.

Dishin' t'scales. Slightly hollowing spring knife scales by hammering them with the peel end of a hammer on a wooden nog in a vice.

To dish To spoil anything. Eh, clumsy, tha's dished that un reight.

Dollop (ˈdɔləp). A lot, a big lump or number of articles.

Dolly (ˈdɔle). A log of wood placed in the wet grinder's trough to adjust the level of water to meet the face of the grindstone. The swarf, or mud from grinding, must be kept within two or three inches of the wheel, as clean water allows the wheel to burn the blades. The dolly is removed after the day's work, so that the stone is not standing in the water all night.

Dolly. A wheel of calico discs clamped together, revolving on a glazer's spindle, and used for polishing, in place of the old-fashioned petch, or hand polisher.

Drawing (ˈdrɔːiŋg). Reducing the size of wire by drawing it through holes of graded sizes in a metal plate called a wirtle. Spring knife cutlers reduce the size of the wire they use for rivetting by this means.

Dress (dres). To cover the face of the glazer with emery stuck on with glue.

Dress. To dress forks is to brighten inside the prongs with a strop dressed with emery.

Dressing hammer (— ˈamə). A hammer with a chisel like face, to cross-cut the face of the glazer, the cross cuts being then filled in with cake emery (beeswax and emery).

Drinkings (ˈdriŋkinz). The afternoon equivalent of biting-on.

Drum (drum). A large, drum shaped pulley, usually carrying several belts or bands. The power end of the transmission, the pulley at the other end being a "receiving pulley."

Drumboard (— buːəd). The board on which one kneels to put the belts on the drum ; the casing about the drum.

Dub (dub). A dub point means a rounded point to a blade, like that of the ordinary dinner knife.

E.

Elsin (ˈelsin). A shoemaker's awl. c.f. Dutch els, an awl.

Equal end (ˈiːkwəl end). A pocket knife with a blade at each end, both ends being the same width, not tapering, as is usual, to one end ; though the term is sometimes used of a knife which tapers equally to both ends.

F.

Facing (ˈfæːsĩn). Protecting soft iron with a hard steel face. Iron hammers for striking and mooding had a steel face ; the vital parts of the stiddy and the devil were also steel faced.

Facing. Smoothing out the steel marks from a newly raced wheel by grinding rough blades heavily on it.

Factor (ˈfaktə). The owner of a factory, subletting rooms and often power to little mesters, whose work he generally bought, marking it with his own trade mark, and selling it as his. A middleman.

Fairin (ˈfɛːərin). Small money gifts from workmen and tradesmen to errand lads and warehouse girls at Christmas and Whitsun, but not the November Fair. Fairins are often included in old apprentice indentures.

Fall hand side (ˈfɔːl and ˈsaid). The moving jaw of the vice.

Fall pin. The pin used to screw up a vice.

Fanny (ˈfane). A "dust masheen," the extractor fan which draws away the injurious dust from a grinding wheel. It is compulsory by law, but the old cutlers often refused to be bothered with it, as it tended to get in the way of their work.

Farrier's knife. A knife specially shaped to pare horses' hoofs during shoeing. Made in different sizes for different operations, in widths of a quarter, five-eighths, three-quarters, and seven-eighths of an inch, with a very narrow blade called a searcher. Single or double edged.

Fash, or fasche (faʃ). A rough, turned edge caused by filing several thin sheets of metal together in a vice ; or a knife edge turned over through sharpening too fine ; any rough protrusion of metal caused by processes of manufacture is a fash edge, including the rough edge squeezed out from between the prints used to shape the bolsters.

Fetching a grinder. In the old days, when a grinder had been away drinking too long his shop mates took a hand cart to fetch him back to work, holding him down in it with a broom. Every inn on the journey was visited, where all took part except the drunkard, who was offered beer tantalisingly, but not allowed to taste it. On arrival at the shop he had to start work immediately. This seems to be the relic of a much more elaborate ceremony, including the recital of traditional nominies, and the flourishing of the branch of a tree.

Fetheredged (fɛðərˈɛdʒd). Having one edge thicker than the other, like an old fashioned razor blade ; anything ground to so fine an edge that it has no strength, the edge wiping over, or turning when used.

Fey, or feighe (fei). To clean out the sludge or mud from anything. A grinder feys, or should fey, the trow under his wheel ivvera neet. c.f. German fegen, to clean.

To fey it. To do anything notably well.

Fire bits (ˈfaːiə bits). Tongs with straight bits, or grips, to hold and fix blades in the fire.

Flash (flaʃ). A spark of red hot scale or metal from a forging.

Flatback (ˈflatbak). A cheap, poorly made knife, the components of which are assembled more or less in the rough, pinned together, then finished off together. The name comes from the flat back of the knife, horns, scales, and spring being ground together in one operation. The Wadsley district was notorious for these poor knives, of which it was said, "We loise o ivvery one we sell, but it's quantity as does it!"

Flat stick (ˈflatstik). A flat piece of ash wood shaped to fit and cover a blade, so that that the grinder may work it on the wheel.

Flat tang (— taŋ(g)). A flat, plate-shaped tang as used in butchers' knives, two wooden grips being pinned one on each side to form the handle, the edges of the tang showing between. A "scale tang" is also a flat tang, but shaped for insertion into a handle, instead of having coverings rivetted on either side ; also a "slot tang."

Flitchmond (ˈflitʃmənd). An anti friction bearing for a grindstone.

Floit, or float (flɔːit). A file, usually one with coarse, straight teeth, single cut. It is sharpened by filing with a three square, or small triangular file, the edges of the teeth then being turned with a burnish, to give a shaving effect to the cut.

Fluted (ˈfliuːtəd). Of knife handles ; carved in any way. A fluter was a superior cutler who could make such handles.

Fly (flaːi). To shear a shape out with cutters or punch out a shape with a machine known also as a fly.

Footale (ˈfutæːl). A new prentice in any workshop was traditionally bound to stand footale, or beer round to all the old hands, before being admitted to his "footing" among them.

For stag (fə ˈstag). Imitation stag horn for knife handles, made of ordinary bone, scratted, or scored to resemble stag.

For buck (fə ˈbuk). The same, to imitate buck horn.

Forenoon (ˈfɔːniuːn). Morning.

Forenoon drinking. Same as biting on.

Foussy (ˈfause). The term applied to the foul atmosphere of the typical old cutlers' shops. Also "frowsy."

Frame (fræːm). The cutler's frame is a structure of wood and iron on which the glazing and polishing of the knife is done. It carries two puppets, upright wood or cast iron blocks carrying the nogs, or blocks of wood which are provided with holes to act as bearings for the spindles of the glazers, etc. These nogs are held in position by means of a hand screw.

French nail (— næːl). A long straight nail nick parallel with the back of the pocket knife blade; i.e., the nick used to insert the finger nail when opening the knife.

Frog blade (ˈfrɔg blæːd). A farrier's knife blade, or searcher.

Frogg. To taper anything.

Front saddle. The front pair of hooks on the horse. (See Backsaddle.)

G.

Gaffer (ˈgafə). A foreman, or supervisor in almost any establishment; even applied to t'schooil gaffer.

Gainshire (ˈgæːnʃə or -ʃaːiə). A barb or notch, like that of a fish hook. The iron tang of a blade is often gainshired to make it hold securely in the handle. "To gainshire" may also mean to bend over the end of the tang when it protrudes right through the end of the handle, thus securing the blade permanently.

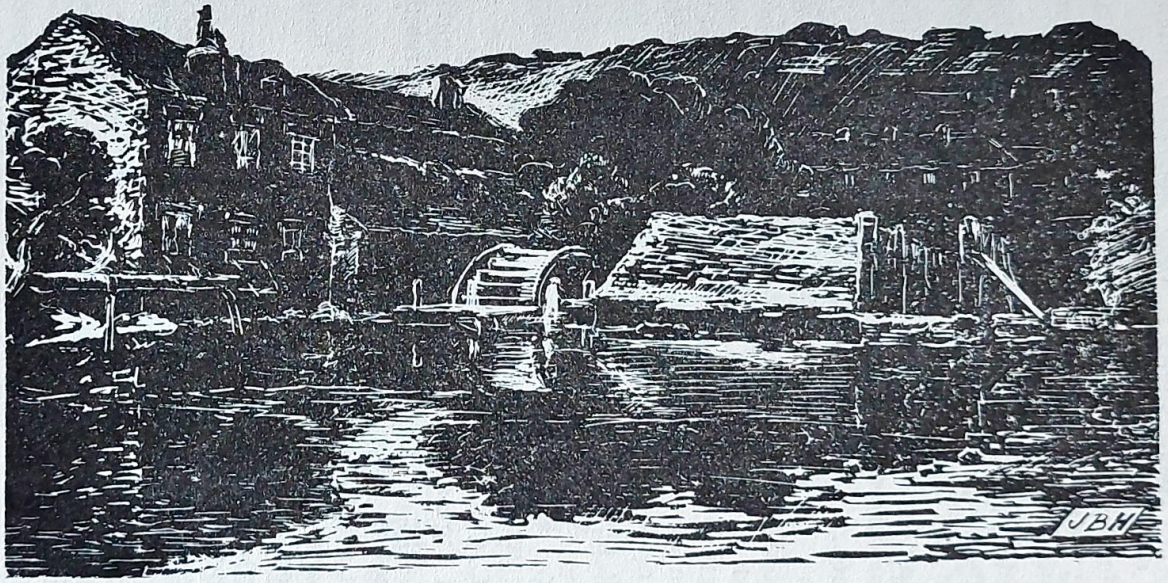
Gane (gæːn). A horizontal piece of metal fastened to the sides of a grinder's trough to hold the wooden bearings of the axle.

Gassing (ˈgasin). 4d. or 6d. a week paid to employers by workmen for the use of gas.

Gavelock, gablek, gablok (ˈgavlək, gablək). A lever or crowbar; a pillar supporting the safety rail fitted to the wall around a drum.

Gillies. Butchers' knives, for Scottish trade.

GROGRAM WHEEL. RIVELIN.
MALIN BRIDGE.



Glaze (up glaze) (glæːz). To brighten cutlery on a glazer; there are two processes, first round polishing on a wheel of wood, built up of wedge shaped segments, the edge of the grain to the circumference, and dressed with pey (rough or pea) emery; then the fine finishing with a cloth dolly.

Glazer (ˈglæːzə). A revolving wheel covered with leather, felt, or any suitable material which can be dressed with glue and emery for polishing purposes.

Glazing petch (— petʃ). A patch of leather worn on the finger to protect it during the old process of polishing by hand, before the day of the power glazer.

Glazer's spindle (— spindl). A power driven spindle carrying the various wheels for glazing.

Goaf (gouf). A coal hole.

Gobbed-on (ˈgɔbdɔn). Soldered on; bolsters, etc., soft-soldered on to the scale of a knife. The expression is said to have arisen because men used to spit (gob) on the article frequently as they soldered it; but it may be a term of contempt indicating that such soldered bolsters were nobbut stuck on we spit, and inferior to the article with a properly *forged* bolster.

Goff (gɔf). An old fashioned trip hammer, worked by water power. Recently the term has come to be applied to any power worked hammer for forging blades.

Goit, goyt (gɔit). A sluice, or mill race.

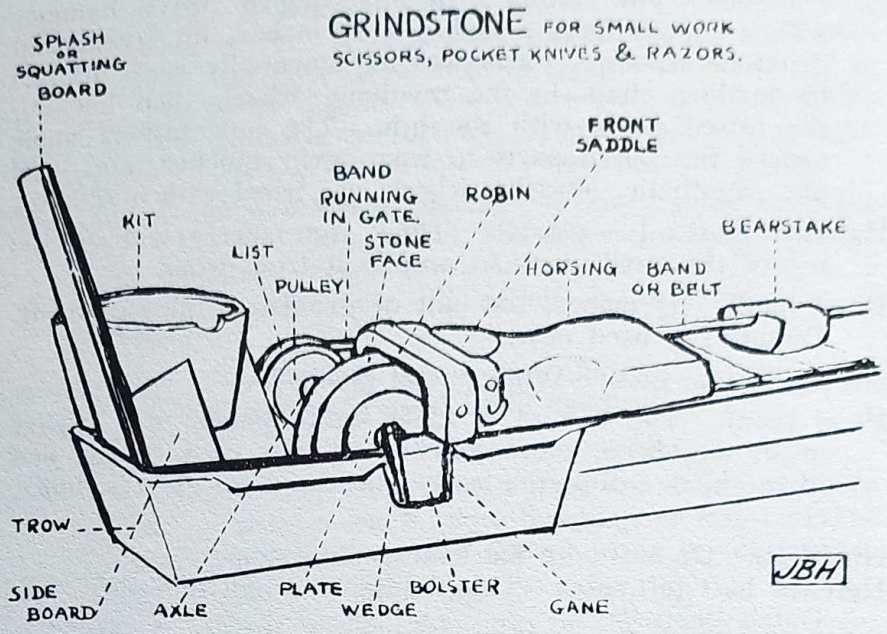
Gooseneck (ˈguːsnek). A smith's chisel of a curious curved neck, like a goose's, the curve giving resiliency when the tool is struck.

Greasy cutler (ˈgriːzi ˈkutlə). A hafter; the man who makes, files, and fits handles. Probably from the bone and horn he uses.

Greet (griːt). Rough marks from the grindstone, which should have been removed during the glazing processes, but have not been bottomed, as they generally lie in some concavity where grinder and glazer have difficulty in reaching them.

Grinder's asthma (ˈgraːindəz ˈasmə). Tuberculosis, caused by breathing the fine dust from stone and metal caused by grinding (silicosis).

Grinder's count. The number of articles ground for every dozen paid for. In the 1880's scale tang knives were 13½ to the dozen, and butcher's knives 14. This was said to cover throwouts, or wasters, but was really an imposition of the factor upon the grinder, said to have been originated by one Wilkinson of Broomhall.



Grindle cowk (ˈgrindl kouk). A grindstone worn too small to be of use for grinding, but used for an amazing variety of purposes. Nearly all the stepping stones and facings of stream banks for miles round Sheffield are made of them ; one used to be the ornament of most kitchen firesides, to hold the potter, or poker ; and the bearstake already mentioned used to stand in one.

Gudgeon end (ˈgudʒən ˈend). The ends of a spindle, running in the nogs, or bearings. A square metal pin was sunk in the wooden axle end, and turned to a point to run in the pedestal.

Gullet (ˈgulit). The hollow between the teeth of a file or saw.

Gulletting files (ˈgulitin ˈfaːilz). Files used for finishing or making the gullets of saws.

Gutting knife (ˈgutin —). A herring gutting knife.

H.

Hammer (ˈamə). The cutler's hammer is noticeable for the fact that the haft is not fitted to the middle of the head but near one end. The balance must be perfect, and a forger will use a hammer he has grown to like until the mark of his thumb on the haft has become a deep hollow. Various kinds are : Mooding hammer, a heavy, flat, steel-faced hammer for making the mood ; tanging hammer, which has not necessarily a flat face ; smithing hammer, a larger, finishing hammer

Hack hammer (·ak ·amə). An adze-shaped heavy hammer with a curved face, 4 inches x 15 inches, for trueing up gritstone wheels. Parts wearing unequally were marked by holding chalk to the revolving wheel, then hacking the raised parts with the h.h. The indentations made caused the raised parts to wear away quicker, and level off. Synthetic, abrasive wheels are trued with a spinner.

Hammer plates (— plæ:ts). Thick iron sheets laid on the top of the anvil stock to protect it from wear.

Hand (and). $3\frac{1}{4}$ inches, the unit of grindstone measurement. Doubtful if used now.

Hard gob (a:d gɔb). White metal (solder).

Head (i:əd). The end of a table knife handle, e.g., spear head, axe head, etc. Sometimes also used of the end of the blade; also the leather head put on glazers. buffs, etc.

Heft (eft). Or haft; to file handles into shape.

Heft, or haft (eft, aft). The handle of a tool or knife. c.f. Dutch "heft."

Heft poip (eft pa:ip). A temporary wooden handle used by grinders to hold the tang of a knife or razor blade during grinding. Generally made in the end of the flat stick mentioned above.

Helve (elv). The wooden shaft of a goff, or power hammer.

Hewin (·iu:wĭn). Just as much work as one hewing, or trimming of the grindstone surface will perform. "When I have worked this week out there will be a hewin of steel left for next week."

Hod (ɔd). A wooden coal box.

Hoe (o:). The rake used for gathering up swarf and scale after grinding.

Holidays (·ɔldez). The old Sheffield holidays used to be at Easter, Whitsun, First Monday in August, Christmas and New Year. Also very frequently Mondays were taken off, known as idle Mondays, or Saint Monda; also a Gala day in July, and probably the November Fair, and certain local feasts, such as Little Sheffield Feast, and Crookes Feast. To this day buffers, at least, are apt to knock off work early on Saint Monda, even though it means loss of money at piece work rates.

Holler punch (ɔlə ·punʃ). A hollow die, or print, used by the hand forger for knocking up bolsters, i.e., pressing the bolster iron into shape.

Horsin (ˈɔːsin). A wooden saddle astride which the grinder sits to his work. It is a thick block of oak, shod with iron back and front, and bearing hooks fore and aft to hold it down by chains. The centre part is rounded like a saddle to make a comfortable (?) seat which the grinder straddles. It is made all in one piece, without joints.

Horse board (see Arseboard, above). A board slung from the roof, at one end, by a chain, the other end reaching over the grindstone. When the grinder sits on it it forms a powerful lever to press the article to be ground on to the stone.

Hottle (ɔtl). A covering for a sore finger; a protective cloth stall to slip over good knife handles.

Housing (ˈaːzin). The framework of a machine.

Hull (ul). A grinding shop; also used for a pig stye, or pig hull, meaning a small, close building, or lean-to. The name of a particular room in the wheel or grinding shop.

N.E.D. gives it as a hut or hovel, sty or pen for animals; sheds considerable light on the conditions under which the old grinders had to work.

I.

Inlaid shell (ĭnlæːd ˈʃel). A special type of hafting made by cutting designs on the scales of a knife and running them full of spelter.

J.

Jackaleg, or jocktileg (?). A kind of spring knife, originally ascribed to a probably mythical Jacques o' Lieges, one of the cutlers who came to Sheffield from the Netherlands in the Sixteenth Century to escape religious persecution.

Jimping (ˈdʒimpin). A milled, ornamental edge to the handle of a pocket knife; notches cut in the back of a handle, or a fluting across the back of a razor tang.

K.

Kelt (kelt). Money.

Kelterment (ˈkeltəmənt). Any type of useless rubbish which gets in the way through being left lying about. "Truck."

Kick (kik). A tiny protrusion from a clasp knife blade just by the shoulder, serving to keep the edge from being blunted by contact with the inside of the spring when the knife is closed.

Kick-striker (— straːikə). A forger's devil, or little chisel fitted to the stiddy for shaping the kick when forging.

Kitt (kĭt). A tub of water for cleaning blades during grinding, to examine the surface; also for filling up the trow. Usually half a small cask. c.f. O. Dutch, kitte, a wooden vessel made of hooped staves.

Knobstick (ˈnɔbstik). A blackleg, or non union workman. Also a man who, in the old days, had served no apprenticeship.

Knifeboard (ˈnaːifˈbuːəd). A narrow tray with raised edges for carrying spring knives from shop to factor.

Ko'trough (ˈkoutrau). A small water container for hardening springs. Cold trough (?).

L.

Lad (lad). The invariable term for a cutler's prentice, who was hardly ever referred to by name, but as Joby's lad, Lomas' lad, etc.

Lagging (ˈlagin). A built up circumference to a drum, made of lags, or pieces of wood, designed to prevent the side slip of the belt.

Lamb foot blade (ˈlamb fut —). A spring knife blade tapering off to a narrow point, for trimming the feet of lambs. Also, a sheep's foot blade, which does not taper so much.

Lamprey (ˈlampre). A plain type of knife.

Lap (lap). To wrap up any article; hence to complete an operation, ready for lapping. Also, to give a final high finish to a blade by use of lead glazer and emery.

Lap (lap). A glazer with a lead surface, for extra fine polish.

Latten (ˈlatn). Thin sheet brass, used for ornamenting knife handles of the cheaper sort. Mentioned by Chaucer, whose Pardoner carried a crois of latoun, i.e., covered with thin brass to shine like gold. From Old French laton, thin sheets of yellow metal. Small washers to go under the rivet heads of razors are struck from this.

Leather stick (ˈleðə stik). A flat piece of wood faced with leather and dressed with fine emery, used to remove any tarnish and give a final polish before a knife is lapped.

Lig on (lig ˈɔn). To lay on, or put on a great deal of pressure in filing or grinding.

Liking (ˈlaːikin). The probationary period of an apprenticeship.

Lilliputs (ˈlilipəts). Mite knives, or children's size knives, up to 4 inches in length.

List (list). The raised edges of a receiving pulley to prevent creep of the band right off the pulley. The pulley is usually in two halves, held together by dowel pin and cotters.

Little mester (litl ˈmestə). A master cutler working on his own, but in a rented room in a factory, paying his own rent and dealing through a factor. The system on which the Sheffield cutlery trade was built up.

Loo (liu:). To be late with work contracted to be done by a certain time.

Lood wark (liu:d ˈwa:k). Work not completed to time.

Loose lead (ˈliu:s ˈled). Lead knocked down into the hole in a table knife handle which is to receive the tang, to balance the blade and keep its tip off the table cloth. This should not be necessary in a good quality knife. Sometimes this lead works loose and rattles, and is then "loose lead."

Lopsided (lɔp:sa:ided). Badly balanced ; out of proportion.

Lozin, or loisin (ˈlɔizin). The coming of age ceremony of a cutler's prentice, heralded by a peal of "bells." rung on suspended "clanging steels," and celebrated with much drinking of beer and singing of the traditional song, "Houd yer licker aboon yer chin." Also used for the coming out time of a chapel!

M.

Maker (ˈmakə). A hand forger who employs a striker when doing two handed work, e.g., a blade makker, scither (scissors) makker.

Makker. A forger.

Marks (ma:ks). Stamps to impress names, trade marks, etc., on a blade ; now often etched on the blade.

Mary Ann. A mysterious and malevolent person who visited the workshops of blackleg workmen and destroyed their tools or machines. (See Rattening.) Now happily obsolete.

Metal. Furnace slag.

Moits (ma:its). Children's size knives and forks.

Moit (ma:it). A mote in the eye, steel or stone in particular. Grinders are expert at removing these.

Mood (mu:d). The rough blank or forging of any article. Also used as a verb. to mood, i.e., mould.

Mottled pig. A type of pig iron.

Mousing (ˈmausin). The glazing down of bone, wood, ivory, pearl, xylo, etc. The name is derived in the first place from the glazing down of bone, which creates a highly unpleasant smell similar to that of mice.

Murl (məːl). To crumble, or burn slowly.

N.

Nailing in (ˈnæːlin ˈin). Assembling and rivetting pocket knives together.

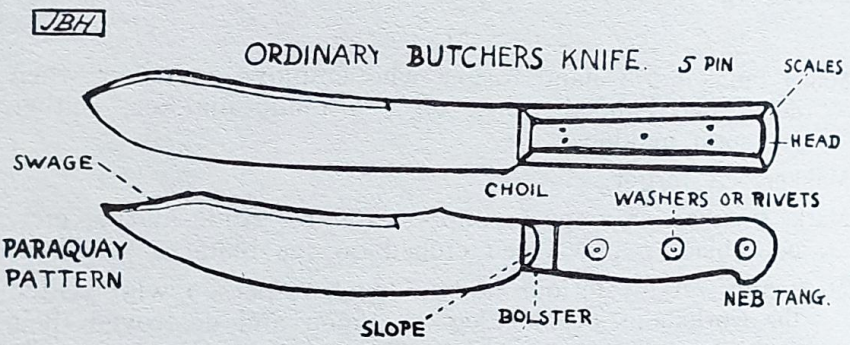
Nail nick (ˈnæːl nik). A little nick by which a knife blade is opened. A short nail nick is in the design of a thin new moon, about the middle of the blade. A long nail nick is a straight nick up the tang of the blade, usually from the bottom of a cut-in swage, which see.

Natty money (ˈnate ˈmune). The contribution paid to a trades' union or Friendly Society.

Neb (neb). The curved tang of a scythe. Neb means any projection, i.e., the nose of a man, or peak of a cap.

Neb hefted knife (neb ˈefted naːif). A blade with a point in middle of the back, like a neb, or nose; sometimes seen in old fashioned carving knives of the cheaper sort.

Neb tang (ˈneb taŋg). Handles shaped to a nose like projection at the head.

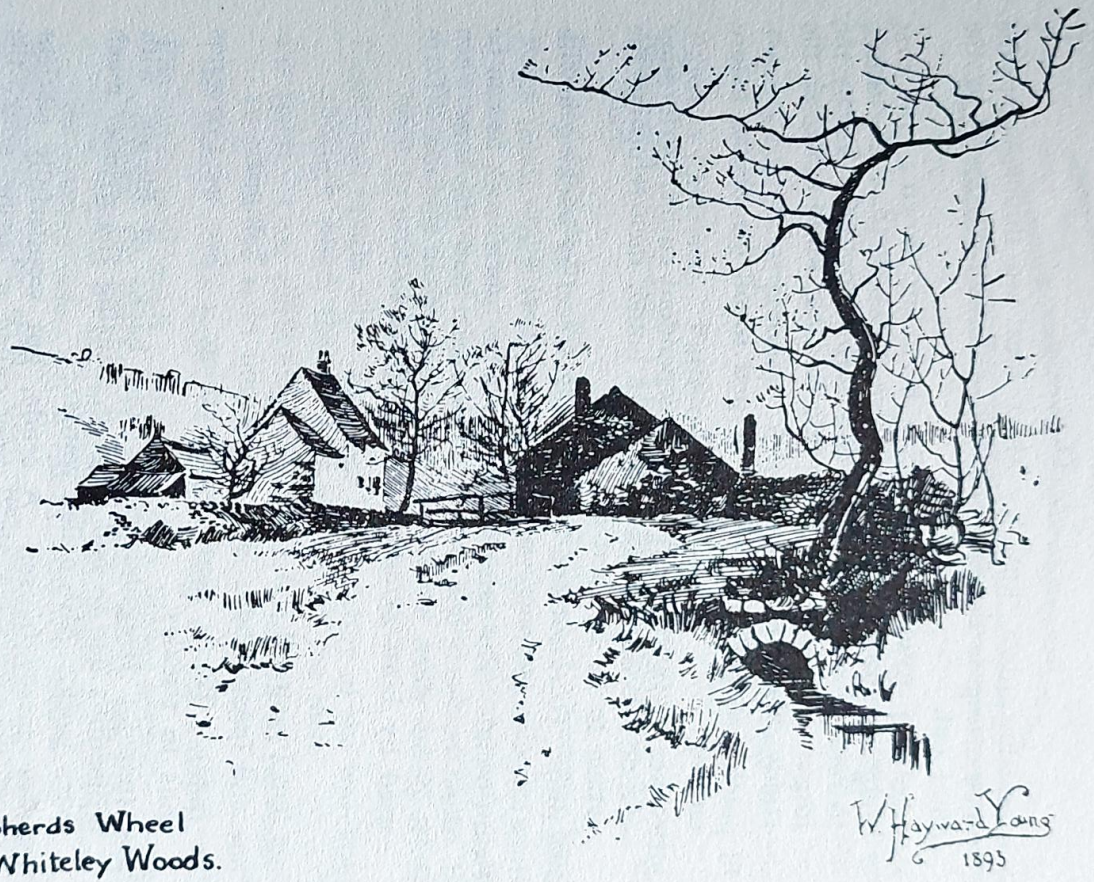


Neck grinding. Buffing with a wheel covered with bull neck leather.

Nickerpecker (ˈnikəpekə). A filecutter; from the sound of a number of them hammering away. Also used of a mean, close-fisted man—"Eh, he's a nickerpecker, yon."

Nogs (nɔgz). Blocks of wood, provided with holes to act as bearings for the gudgeon end of a spindle.

No-bowster (nou-ˈboustə). A flat knife tang without a bolster.



Shepherds Wheel
Whiteley Woods.

Notch hollow (ˈnɔtʃ ˈɔlə). The notch in the handle of a pen knife where the thumb goes to reach the nail nick to open the blade.

Nubbock (ˈnubək). A lump of anything, generally in some place where it is not wanted.

O.

O-er cutting (owə ˈkutin). Most files are double-cut ; the o'ercutting is the first cutting, and this is crossed by the final cut.

O'er holding (owerˈoudin). See breaking down ; the first rough grinding, requiring more pressure than any other, to remove all inequalities and surplus material left by the forger. Gives a good flat side to a big knife to lay on the stiddy when setting.

Oil petch (ˈɔil petʃ) or patch. A pad to oil file blanks before cutting.

Outworker (ˈa:twə:kə). A small independent cutler, performing one or two operations in his own home, then returning the article to be finished by others.

Owe (ou). To re-surface the grinding wheel by hacking it with a special hammer, which has a chisel edge.

Owin (ˈowin). The same as Hewin' ; as much work as can be done between one owin of the wheel and the time when it is so worn as to present an unequal surface. Term used by both grinders and up-glazers.

P.

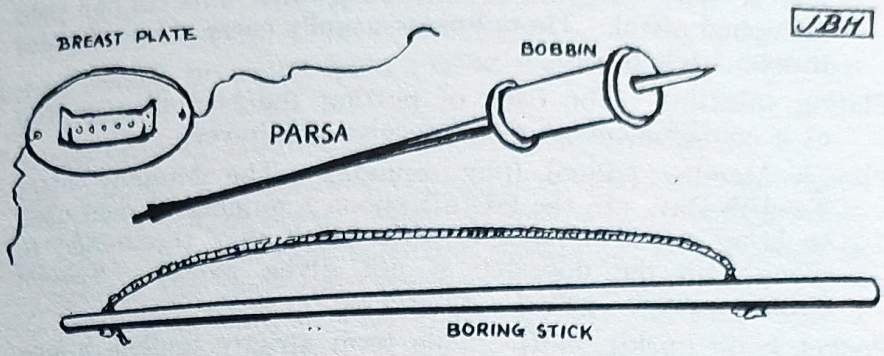
Pair 'em (ˈpɛ:ərəm). A striker and his man.

Pane end (pæ:n ˈend). The sharp end of a hammer.

Pan (pan). To fit neatly to anything. "See as t'coverins pans to t'scales."

Paps (paps). Irregular edges and backs of blades, with projections due to bad forging, causing the grinder much extra work. Also called wants.

Parser or parsey (pa:se). A crude, but wonderfully efficient drill, worked by a slack bow called a boring stick, the string of which passes round and rotates the parser heft, or bobbin, one end of which runs in a bearing formed by a pierced plate strapped to the cutler's breast, while the other carries the drill. Even to-day there are certain operations where the parser can beat any modern drill. See two legged parser.



Parser heft (ˈpɑːsərˈeft). The bobbin, or miniature drum round which the "whitleather thong" of the boring stick passes.

Patents (patnts or peːtnts). Anything novel in cutlery is called a patent.

Pattrens (ˈpatrənz). Patterns or templates.

Peaky end (ˈpiːki end). The sharp end of anything, e.g., the blade.

Peel end (ˈpiːl end). The pene, or sharp end of a hammer head.

Petch (petʃ). A pad made of a number of thicknesses of cloth, used to rub shaved bone handles to a polish, before the introduction of the power driven dolly. Sometimes the name was given to a piece of leather with a loop at the back to protect the finger from the glazer.

Pickin hoil (ˈpikin ɔil). The door in the lobby of the warehouse through which the work is allotted to the men.

Pie (pɑːi). Coal packed on the forger's hearth to be reduced to cokes for next morning ; now unnecessary.

Pike (pɑːik). The beck, or pointed end of the anvil.

Pile side (ˈpɑːil sɑːid). The side of a blade, opposite to that carrying the mark. It is the side where the iron of the tang is piled up on the steel of the blade. Also known as the reverse side. Of a razor, also the reverse side.

Pins (pinz). The rivets used for assembling knives during nailing in.

Pinnin on hoils (pinin ˈɔn ɔilz). Holes drilled for the rivets used to fasten the covering on spring knife handles ; not used of the holes for the rivets which fasten in the blade and spring.

Pistol haft (ˈpistəl aft). A common type of pocket knife which has a haft somewhat resembling the butt of an old fashioned pistol. These knives usually carry a round point thrown back blade.

Plating (plæːtin). The trick of putting the best files on top of a consignment so as to deceive the buyer.

Plough Monday (-Ploo) (pluː ˈmunde). The Monday after Twelfth Day. In the late afternoon a number of men used to bring round a plough, with which they threatened to plough up the doorstep if not given money. Special nominies were recited. Obsolete.

Pocket knife (ˈpɔkit naːif). This term strictly implies a one ended knife, i.e., with blade or blades opening from one end only).

Pod (pɔd). A small pointed knife.

Points (points). Hard steel pins used by cutlers for temporarily assembling knives while finishing them.

Poking (ˈpoukin). Being forced to take work to another grinding shop and borrow room to work, when one's own wheel is at a standstill.

Potter (ˈpɔtə). Poker, for the fire ; generally stood by the hearth in an old grindle cowk.

Pressed scales (prest skæːlz). Horn scales pressed into the required shape. "Prassed uns" for very common knives were made from cows' horns, after softening them by boiling.

Pulley (ˈpule). The wheel receiving power from the drum.

Q.

Quarter cleft (ˈkwaːtə ˈklif) or quarter cliff. Shin bones split into four quarters before sawing up for handles. The whole is known as Whole booan.

Quench (kwenʃ). To temper a heated blade in water or oil.

R.

Race (ræːs). To true up irregularities of wear on a grindstone by running it, and passing a pointed rod of iron or steel over the surface. This is racin t'stooan, though the wheel is run slowly, not raced in the modern meaning of the word.

Race. The trench like portion of a grinding hull below the floor level, in which the lower part of the driving belt travels.

Racing iron (ˈræːsin ˈaːiən). The pointed rod of iron or steel used in racing a worn stone.

Raddle hoil (ˈradl ɔil). A yellow nodule, or flaw in a grindstone of sandstone, which shows a deposit of softer texture, which will wear away unevenly.

Rahnd heead, or round head (ˈra:nd i:əd). The rounded end of a knife handle.

Rammel (ˈramil). Refuse of any kind ; kelterment.

Rand (rand). A decorative edging, cut round the handle of a table, fish, or dessert knife, by means of a randing knife.

Rap (rap). A blade raps when the kick is not high enough to prevent the blade from resting on the spring when closed. Any slight fault, or rap, in the spring, will then cause a notch in the blade.

Rape (ræ:p). A file, more particularly used for filing handles.

Rape. To file down with a rough rasp.

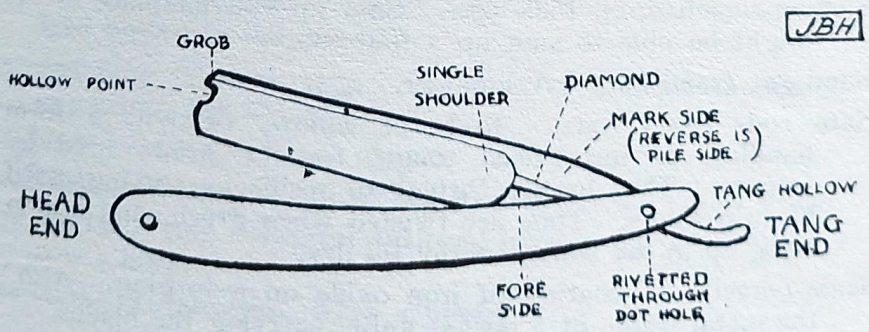
Rape. Modern ; a revolving wheel with file teeth on the circumference.

Rat tailed bolster (ˈrat tæ:ld boustə). A bolster with a hollow in it, so called because it was shaped with a rat tailed, or thin round file.

Rat tailed file. A very slender round file.

Rattening (ˈratnin). Wilful damage of machinery by strikers. A favourite method of disposing of a blackleg grinder was to drive in the pegs which secured his wheel to the spindle, slightly cracking the stone, which would show no flaw till set in motion, when it would burst. Gunpowder was also put in the troughs of dry grinders, to be lighted by the sparks when he started work ; or in the furnaces of forgers. Warnings and triumphant letters after a successful attempt of this sort were nearly always signed Mary Ann. Fortunately this downright method of settling disputes is obsolete.

Raken sleck (ræ:kn slek) or raking slack. Small slack coal used to rake, or damp down a hearth fire which is to be left, to make it burn slowly.



Reckon (ˈrekn). To settle up wages. "Has ta reckond?" means "Have you had your wages?"

Resurrection pie (ˈrezərekʃn ˈpai). A pie made of "potatoes and scrag ends o' owd meit"; an unsavoury dish to which cutlers were generally reduced towards shank end o' t'week.

Reverse knife (riˈvəːs naːif). A knife with a haft similar to that of a pistol haft, with the handle reversed. Usually carried a sheep foot blade.

Revits (ˈrevits). Rivets.

Rim (rim). The small ridge round the bolster of a table knife.

Roak (rouk). A small surface defect on a table knife blade, often a seam caused by bad welding. A roky blade can often only be detected after grinding. Generally found in shear or double shear steel.

Robin (ˈrɔbin). The steel front of the horsin, against which blades are levered on to the grinding wheel with the flatstick. This saves wear of the horsin.

Rockstaff, or rodstaff (ˈrɔdstaf). The handle of a great bellows of the old type; generally fitted with a whole cow's horn at the end to make a comfortable grip.

Rozzil (ˈrɔzil). Resin, used for fixing the tangs of blades into the handle.

Rotten stone (ˈrɔtnstən). A brown, soft stone used, mixed with oil, for fine buffing, especially of silver.

Rough buffing (ruf ˈbufin). The first buffing of a blade, instead of the older up- or side- glazing.

Rubbed bone (ˈrubd ˈbuːən). A very special quality of bone handle.

Rubbing (ˈrubin). Hand polishing to give a very smooth finish to a bone handle.

Sam up (ˈsam up). Pick up. "Sam up yon hammer." "O might be able to sam up a few bob."

Sand rat (sand rat). A moulder.

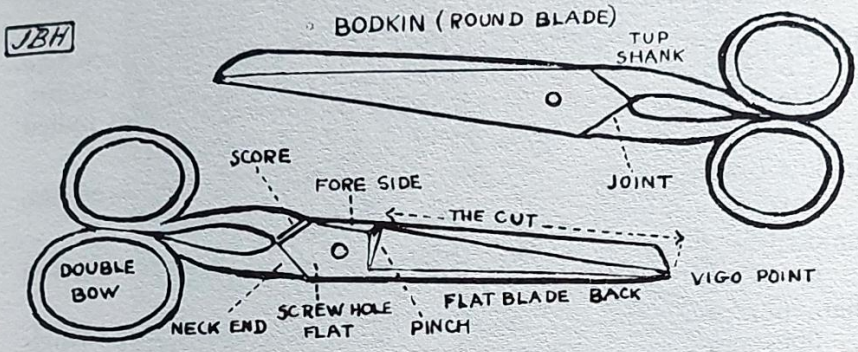
Sate rods (ˈsæːt rɔdz). Rods of willow, twisted to form handles, or improvised tongs, for the prints used by forgers. They have a "give" or resiliency not possessed by iron tongs. They are twisted when green, and left to hang up in the warm smithy till dry.

Scale (skæːl). A coating of iron oxide on a forging. Also, the metal frame of a pocket knife, carrying the blades.

Scale. Is sometimes also loosely used to imply the covering of bone, wood, pearl, etc., rivetted on to these metal scales.

Scale tang (— taŋ(g)). A flat knife tang, the handle consisting of two scales pinned on either side of the tang. Used to be paid for at the rate of 14 to the dozen.

Scarf (ska:f). The part of a weld where the two metals are tapered down at the edges to assist the welding.



Scorch (skɔ:tʃ). To overheat a blade by grinding, and so spoil its temper ; also, to smooth the shoulder of the blade where the mark is to be set ; also to grind over for the first time, like breaking down or laying-on.

Scoring knife (ˈskuːərin naːif). A knife with teeth cut in it, to make an improvised saw for cutting wire.

Scotchman (ˈskɔtʃmən). A small piece of wood nailed to the drum-board to prevent bands from slipping over the edge of the drum and snarling or collaring with the axle. There were three to each wheel, front, back, and centre, under the flange of the drum, so that even if the band did slip right over, it could not reach the axle.

Scratted bone (ˈskratəd ˈbuːən). Scored bone scales, usually dyed brown to imitate stag.

Screwed tang (skriuːd ˈtaŋ). The tang of a blade tapped to screw into the handle.

Scummer (ˈskumə). A fire shovel.

Seeat booard (ˈsiːət ˈbuːəd) or seat board. A file cutter's seat

Self tip (self ˈtip). Natural coloured horn ; the solid tip of a cow's horn.

Set (set). To sharpen, whet a blade.

Set. A setting hammer with which the grinder hacks a twisted or crinkled blade on the stoop, with a stiddy held between his knees.

Setter in (ˈsetərˈin). The man who assembles the various components of a knife without completing the finish, as the older cutler would have done.

Setting clog (ˈsetin klɔg). A log of wood with a small steel block set in its end, for straightening b'ades ; really a small anvil on a long stock held between the knees ; c.f. the stoop and stiddy used with the set, above.

Setting hammer. A set, a hammer with a V-shaped face like a blunt chisel, used on a round stiddy to straighten blades. The blade is hit on the INSIDE of the hollow and pulled up, not beaten in, as might be expected.

Shadow (ˈʃadə). A spring knife without bolsters, i.e., with the coverings extending the full length of the handle.

Shakked bone (ˈʃakt ˈbuːən). Bone cracked through drying too quickly.

Sham pin (ʃam ˈpin). A pin or rivet in a table knife which does not pass through the tang. Such are often put in cheap knives to make them look like better quality articles.

Shave (ʃæːv). To scrape bone handles to give them a finish.

Shaved bone (ʃæːvd buːən). Bone handles finished as above, by scraping with an old razor with a turned edge, or with a knife ground to a skate edge (fetheredge).

Shaving knife. An old blade whetted to a skate edge for shaving handles.

Shell tang (ˈʃel taŋ(g)). A flat tang without a bolster.

Shemming end (ˈʃemin end). The tail end of a weld ; if imperfect union takes place a small cavity may be left.

Shield plate (ʃiːld plæːt). A plate with a hole cut in the shape of the ornamental shield to be let into a knife handle ; in this template the cutting legs of the two legged parser are guided.

Shim (ʃim). A thin washer, for machinery.

Shog (ʃɔg). To oscillate. Extended to personal use ; to waddle in one's gait.

Shoot (ʃiuːt). To weld iron to steel, e.g., welding of the bolster iron, which forms the bolster and tang, to the steel of the blade.

Shot blades (ʃɔt blæːdz). Blades with welded iron tang and bolster piece (not always hand forged).

HOLLINS BRIDGE MILL
RIVELIN
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Shot sithers (— siðəz). Scissors with bows of iron welded to steel blades.

Side (sa:id). A cutler's side is a portion of a bench in a common workshop, rented by poor cutlers or setters-in, on which they assemble knives.

Sitter (ˈsitə). A setter, or print for setting down the choil.

Skaarin iron (ˈska:rin ˈa:iən) or scouring iron. An iron rod used to trim the surface and sides of a grind stone, like a racing rod.

Skate edge (ˈskæ:t edʒ). See fashed edge.

Skeller (ˈskelə). To bend or warp with heat.

Skerrick (ˈskerik). A little morsel of something.

Slack (slak). Short of work.

Slag (slag). Metal refuse in cokes, which gets on to the blade surface in the hearth and prevents proper heat treatment. Also called clinker.

Slape (slæ:p). To neglect, or "sluther o'er" one's work.

Slape joint. A common pocket knife joint.

Sleeve board (ˈsli:(ə)v bu:əd). A two ended knife, broader at one end than at the other, like the old fashioned ironing board.

Slice (sla:is). A blade with a round point. A ham slice was $\frac{3}{4}$ in. broad, and of various lengths ; a beef slice was seven-eighths broad.

Slitspring (ˈslitspriŋ(g)). A spring solid at one end and slit at the other to work two blades in a pocket knife.

Slot bolsters (ˈslɔt ˈboustəz). Bolsters whose back portion protrudes to allow of a ferrule being let on to the handle where the tang fits in, as seen in some carving knives, etc.

Smither (ˈsmiðə). A man who straightens up, by hand, machine-made file blanks or blades.

Smithum (ˈsmiðəm). Slack coal.

Smithy sleck (ˈsmiðe slek). Scales of iron oxide which fall from a blade during forging.

Smook (smu:k) or smoke. The black reek from burning greasy cotton waste, deposited on bone handles prior to shaving, to show up any parts which are neglected by the shaving knife.

Snape (snæ:p). To slope down ; two pieces of iron are snaped down ready for welding.

Snaith (?). The crooked handle of a scythe.

Snaps (snaps). A sort of horizontal vice, with a long flat projection on the lower jaw, in which cutlers screw horn or stag scales to be levelled off.

Soaking (·so:kin). The uniform heating of a blade to temper it.

Soft (soft). A porous surface, of poor bone handles, or badly tempered blades.

Sog (sɔg). Very heavy work, or as a verb; to work very hard, i.e., "sog into it!"

Solid handles. Blades forged solid from square steel, handle included, all of a piece. Mostly used for dessert and table knives.

Sours (·sa:uwəz). Work done for which the money has already been subbed, or drawn in advance.

Souring or sahwering. Drawing pay for work not yet done.

Sow metal (·sa:u metl). The most inferior type of pig iron.

Sozzels (·sɔzilz). Hemp cutting knives; common butcher pattern.

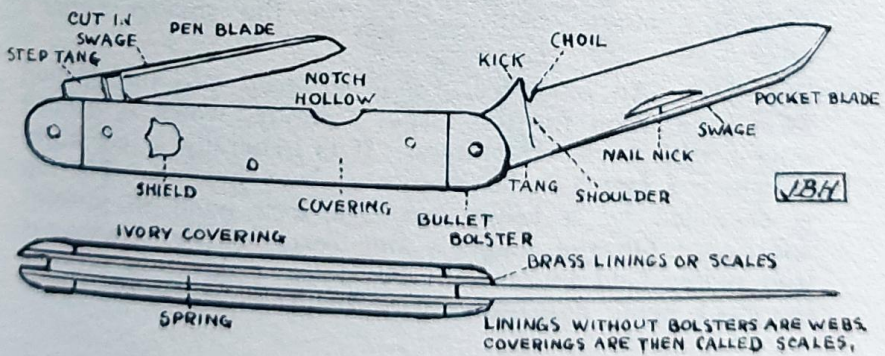
Span (span). Same as "hand"; $3\frac{1}{4}$ in., a measure for grindstones.

Spinner (·spinə). A tool for trueing up abrasive wheels; consists of five little sharp serrated wheels set on a handle like a common pattern of glass cutter; for the same purpose as the racing rod of the old fashioned sandstone wheel.

Spinner. A tool used by grinders for grinding three-square files. It is made from an old file bent to a hook at one end and fixed to the front of the horseboard to use as a pivot for the file to be ground.

Splitters (·splitəz). $5\frac{1}{2}$ in. broad twisted square point whittle tangs, with wooden handles, for fish dressing.

Sploder (·splɔ:də). To splinter or split small pieces from the surface of the covering, round the rivet of a pocket knife.



Spring knife (ˈspriŋ naːif). A knife in which the opening and closing of the blades is controlled by a spring. Commonly, but often mistakenly known as a penknife.

Squat board (skwat ˈbuːəd) or squatting board. The board placed in front of a grindstone to catch the splashes, or squats of swarf, or mud, thrown off by the wheel running in the trow.

Stafford (ˈstafəd). A small palette knife for pottery manipulation. Named from the place of its use.

Stag (stag). The horn of which knife handles are made.

Stage (stæːdʒ). A small wooden platform, often adapted from a wooden box, behind the cutler's vice, to hold his tools ready to hand.

Stage. A small wooden platform or flat box of a height suitable for raising a short boy up to allow him to work at the vice or glazer frame.

Stail, or stele (steil). The long handle of broom, rake, hammer, etc.

Stake (stæːk). A silversmith's anvil.

Steeple (stiːpl). To form a point at the bottom of the hole drilled in a haft, to take the end of the tang.

Stiddy (ˈstide). A cutler's stiddy is a small iron anvil with a tapered square shank, which is driven into a hole in the bench . It is used for rivetting. It usually has a flat beck at the back, and a slot through which to put the wire when nailing-in ; and a round hole in the left-hand side. Often it is supplied with burritting holes for finishing off rivet hands in an ornamental form.

Stint (stint). A small amount of work for a cutler on short time.

Stirrup (ˈstirəp). Loop for a file cutter's foot strap.

Stithy (ˈstiðe). An anvil ; generally the larger kind for forging, "stiddy" being used for the smaller cutler's anvil.

Stock (ˈstɔk). An oak tree stump let deep into the ground as a foundation for the forger's stiddy, which is bedded into it with horse droppings. It is generally 5 feet high, of which 2 feet 3 inches projects above ground. The top is encircled by a heavy wrought iron band to prevent splitting. On the forger's side rests loosely a wrought iron plate, held in position by three wedges, to prevent the stock being damaged on the forger's side of the anvil.

Entrance to the
First Endcliffe Wood
now demolished.
W Hayward Young

Striker (ˈstrɑːikə). The forger's assistant, or mate.

Sub (sub). To sour, or borrow money in advance of payday.

Suck (suk). To grind too closely, pulling up one side of the blade, so that a hollow is formed too deep to be bottomed.

Sump (sump). A hole, generally for some waste liquid to drain into.

Sunk joint (suŋk dʒɔint). A spring knife with the backs of the blades sunk level with the handle, unlike the common joint, in which the blades project above the surface.

Swage (swæːdʒ). A long, ornamental bevel down the back of a knife blade. Any kind of bevelling may be known as a swage.

Swage block (ˈswæːdʒ blɔk). A piece of iron with many variously sized hollows in it.

Swagging (ˈswagin). The sideways, slapping motion of a slack driving belt.

Swamp (swamp). A flat or hollow, especially in a handle. "These hefts is full o' swamps."

Swarf (swaːf). The yellow sludge of water and stone dust left in the trow (and over most parts of the hull!) from wet grinding.

Swarf hoil (ˈswaːf ɔil). A pit or other place to deposit the swarf cleaned from the troughs every night.

Sway knife (ˈswei naːif). A long, straight or curved blade, swaying about a pivot at one end, the other being continued into a wooden handle. Used by cloggers and horn cutters. It is similar in action to the guillotine used by tobacconists and paper cutters.

Sweets (swiːts). The opposite of sours. Goods delivered, but not yet paid for.

T.

Tache (tæːtʃ). A small piece of hard wood let into the front of the bench as a support when filing or drilling handles.

Take down (tak daːn). To file or grind down an over-large article.

Taking agean (takin əˈgiːən). The filegrinder's equivalent of "cuckoo" ; correcting faulty work in filecutting.

Tak thi hook (tak ði uːk). Depart in a hurry!

Tally (ˈtale). An article laid out prominently from the rest to mark a given number, in counting.

Tang (taŋ(g)). The metal spike or scale by which the blade is fitted into the heft of a knife. In hand-forging it is usually made from a separate piece of iron, welded to the steel blade.

Tangs (taŋ(g)z). Tongs. c.f. Dutch, tangs.

Tatching ends (ˈtatʃin endz). Threads of hemp, waxed and twisted, with bristles at each end, as used by grinders and cutlers to sew the ends of their driving belts together. "Attaching ends."

Team. A body of workers associated in production, e.g., Ah work wi' a teeam.

Teem (ti:əm). To pour any liquid, or molten metal.

Tempering (ˈtemperin). Reducing the hardness of steel.

Three legged stool. The stool used by old cutlers at work, also by diminutive prentices, too short to reach the glazer or bench.

Through tang (θriu: taŋ(g). A knife with the tang containing right through the head of the handle.

Thrusting stick (θrustin stik). A piece of wood held up on the other side of a scale while a cutler is boring it in a vice, to prevent the drill bursting through and splintering the scale.

Thrussen (θrusn). Crowded, or pressed. "Better be thrussen for room nor thrussen for rent!"

Throater (θroutə). A $5\frac{1}{2}$ in. spear knife with turned wooden handle, for dressing fish.

Thumbhandside (θumand sa:id). The right hand side.

Thumb petch (θum petʃ). A thin piece of leather attached to the thumb to resist friction when buffing.

Thumb mark (θum ma:k). The patch or mark on a blade where the iron tang piece, or bolster iron has been welded on to the blade. Supposed to be the sign of a good handforged blade, but can be imitated in a stamped article.

Tine knife (ˈta:in na:if). A knife with a handle in the shape of the natural tip, or tine, of a cow horn; made by sawing the horn down the middle, and pinning half on each side of the tang.

Tines (ta:inz). Prongs, or points of any instrument, e.g., a fork.

Tilt (tilt). A forge; a power hammer, originally one worked by water power; a "helve" or "trip hammer."

Tingle nail (tiŋgl næ:l). An ordinary tin tack, used for fastening weights to balance the glazer.

Tip (ˈtip). The end of a cow's horn ; the end of a handle made of buffalo horn.

Tommied on bolsters (ˈtɔmid ɔn —). Bolsters made separately, pinned on to the scales of a pocket knife later, not forged at the same time as the scale. The german silver bolsters of high-class knives are usually tommied on. The bolsters are cast with a peg on the under surface, then bossed in a die, which rivets the peg on to the scale.

Trow (trau). A trough, such as that in which wet grinding wheels run.

Truck (truk). Cinders, slag, and other waste matter ; by transference, any kind of rubbish.

Trump (trump). A common spring knife.

Tue iron, or tu'un (ˈtiuən). The metal nozzle protecting the pipe of the bellows where it enters the forger's hearth. Generally it is hollow, and cooled by a simple circulatory water system supplied by a tank or "bosh."

Tuier, or twyer pan (ˈtwaiːə pan). The square cistern supplying the tue iron.

Tumbler (ˈtumblə). A pocket knife spring.

Tumbler. A broad glazer about 20 inches in diameter for rough glazing after whittening blades. It is the modern form of the up-glazer, and reveals any surface defects very easily, a necessity when the articles are to be plated, which shows up the least fault.

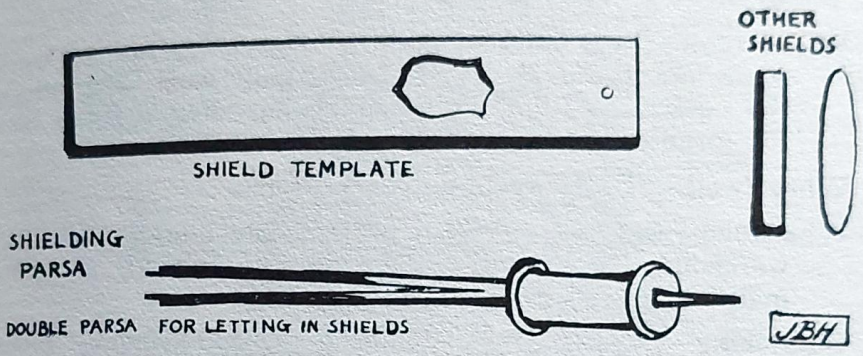
Tumbletree (ˈtumblˈtriː). The massive beam forming the fulcrum about which the rodstaff of the old fashioned bellows oscillated.

Turnfile (ˈtəːn faːil). The tool or burnish used to put a fine turned edge on each tooth of a floit (coarse file). Usually made of an old file (that stand-by of the cutler !) of which about three inches above the tang were forged to fit the teeth of the floit, then ground, hardened and fine glazed. It was used by putting the floit in a vice below the chaps, which then acted as stops for the turnfile. Each tooth of the floit is then whetted individually.

Turning the hat. A term used by hand file cutters when working under trade prices ; ¼ round meant a cut of 5 per cent. ; ½ round, 10 per cent. ; ¾ round, 15 per cent. ; and all round, 20 per cent. below agreed prices.

Twyer (twa:iə). The pipe carrying the forced draught from the bellows to the forger's hearth. French tuyère, a pipe.

Two legged parser or shielding parser. A parser (q.v.) with a curious bit, consisting of two cutting legs sprung from a common joint, and mounted in the parser bobbin. These two legs open and close as the drill revolves, following the outline cut in a template, or shieldplate. Thus the cutler can cut a hole of any shape, square, diamond, etc., with a rotary drill, a feat engineers often say is impossible until they have seen it done.



U.

Upglazing (ˈupglæ:zin). Buffing a blade on a wooden wheel to remove scratches and give a fine black finish. So called because the blade is held up the wheel, not across it in the usual way.

W.

Waag. A lever ; obsolete. c.f. Dutch waag, a balance.

Waled edges (ˈwæ:ld edʒiz). The edges of a vice with the corners forged off into octagons, instead of square edges. Done solely for ornament.

Wallet (walit). A sack with a pouch at each end to hold work, and carried slung over a man's shoulder like a scarf, one pouch in front, the other behind.

Wants (wants). See paps.

Weahrus, warus (ˈwi:ərəs, wɛ:ərəs). Warehouse.

Waruslass (ˈwɛ:ərəslas). Warehouse woman, who finally whetted the blades on a whetstone, then lapped them, i.e., wrapped them up.

Wasters (ˈwæːstəz). Imperfect articles, throwouts. Applied by transference to worthless, good for nothing fellows.

Water bobbies (ˈwatə ˈbɔbez). Hardeners, or temperers. A file cutting term.

Waterloo bolster (ˈwɔːtə liuː). A bolster with a triple ridge cut round it. Now called an egg bolster.

Werligig polishing (ˈwəːligig). The scornful name applied by old cutlers to the method of polishing by power glazers and dollies when it first came into use.

Wheel (wiː(ə)l). The invariable term for a grindstone ; also to the shop containing it.

Wheel rent. Rent paid by a little mester for hire of work room and power in a factory ; usually used by grinders, the equivalent term for cutlers being shop rent, as also for forgers.

Whet (wet). To sharpen knives or tools.

Whetstone (ˈwetstən). A slab of Brincliffe blue stone. The warehouse women swish the knife edge quickly along to make a keen cutting edge.

Whittening (ˈwitnin). Whitening ; second-grinding table knives after first grinding them on a blue Brincliffe stone ; they are sharpened on a stone so smooth that no fether-edge comes.

Whittening stone (— stuːən). A finer grit than the rough stone used for first grinding. Obtained from Brincliffe Hill, and called blue-stone.

Whittle (witl). A poor, dull knife ; a very early type.

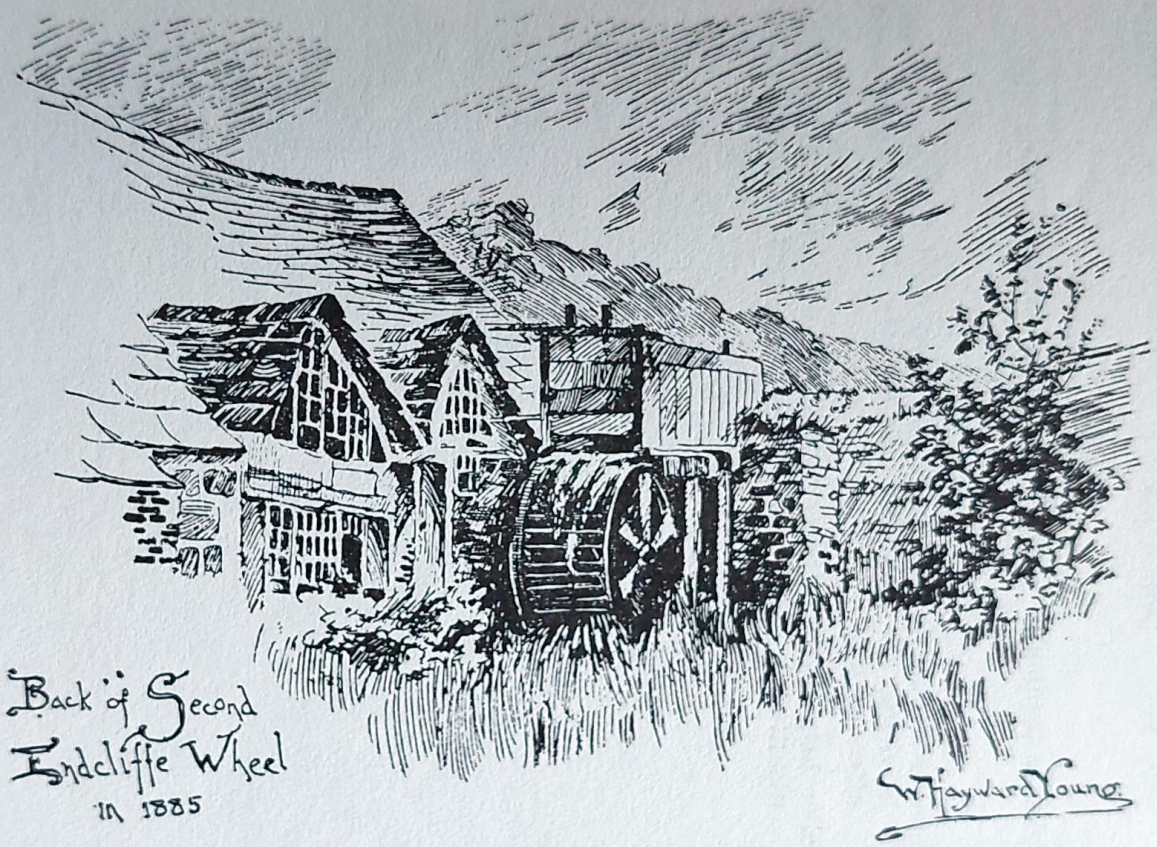
Whittle tang (— taŋ(g)). A narrow flat-tang, without a bolster. The earliest type of knife, simply knocked together. Used for splitting rather than cutting.

Wimble (wimbl). A boring tool.

Witch (witʃ). A thin wooden wedge inserted temporarily between the scales of a knife to keep them from bending inwards during the rivetting process. It also serves to prevent the scales from being rivetted together too tightly.

Wiping clout (ˈwaːipin klaːt). A rag used for wiping off the dirt or dust from finished work.

Whole bone (ˈwoul buːən). Whole shin bone, used for handles.



Back of Second
Endcliffe Wheel
in 1885

W. Hayward Young

Work notes (ˈwəːk nuːəts). Notes, or order forms describing the work to be done.

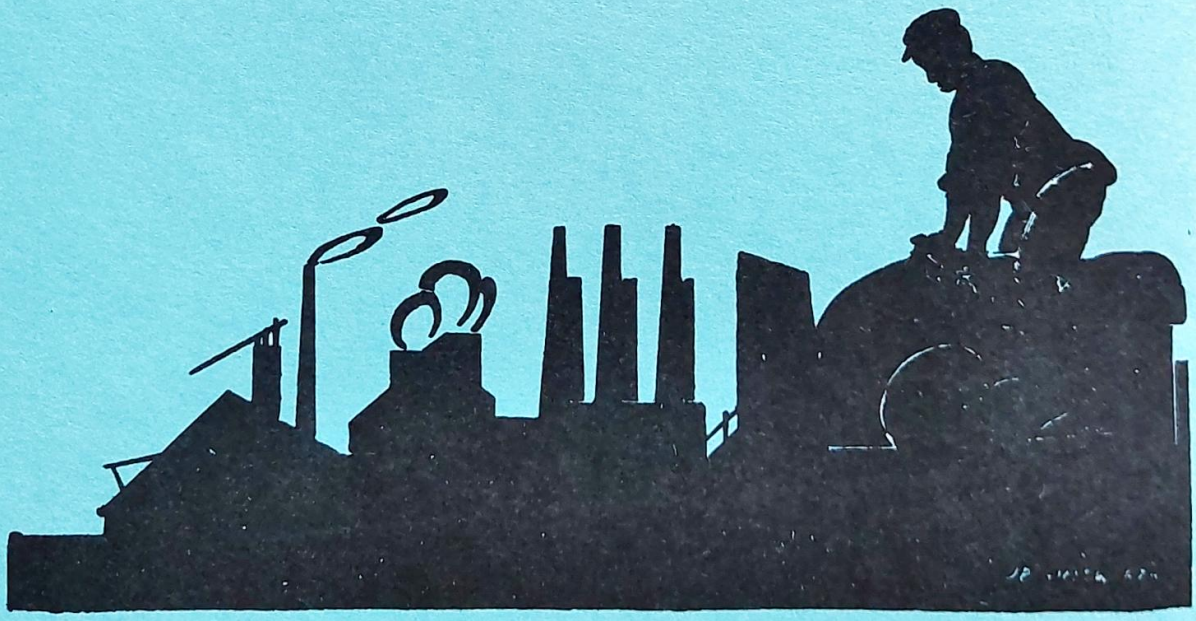
Wortle (wəːtl). A plate pierced with specially tapered holes, for drawing wire for rivetting. Also "wordle."

Wortle pricker (ˈwəːtl ˈprikə). A man who bores wurtles, a very highly skilled job.

X.

Xylonite (zaːilou). Used for handles instead of bone, etc.

Y.

Yarmouth Beef (jaːməθ ˈbiːəf) or two eyed beef steak ; red herrings, the only beef the poverty stricken cutler could often afford.

Yaller belly (ˈjalə ˈbele). A grinder, so nicknamed from his plentiful daubing with the yellow swarf from the wheel.